



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-C-05
Job Sheet 170612



Part No: RBE350A94-3700-C-05

Job Qty: 18 ea

Part Name: Bottom



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		2/13/18	0.00	0.00	Start Up Machining-3		<i>mf</i> 18/02/08
110	Bandsaw	18 pcs		2/13/18	0.00	1.80	Bandsaw1		<i>mf</i>
120	Mori Seiki	18 pcs		2/13/18	0.00	9.00	MORI NV5000-1		<i>mf</i>
130	QC	18 pcs		2/13/18	0.00	0.00	QC2 Machining-2		<i>mf</i> 18/02/08
140	QC	18 pcs		2/13/18	0.00	0.00	QC8 Machining-3		<i>mf</i> 18/02/11
150	Outsource	18 pcs		2/13/18	0.00	0.00	Outsource4		<i>mf</i> 18/02/11
160	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging3-2		<i>mf</i> 18/02/11
170	QC	18 pcs		2/13/18	0.00	0.00	QC6		<i>mf</i> 18/02/11
180	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging3		<i>mf</i> 18/02/11
190	QC21-SA	18 Ea		2/13/18	0.00	0.00	QC21		<i>mf</i> 18/02/11

Part Op 110 - Cut blanks to 1.30"

Descriptions: 120 - 1-Machine as per folio FB 776
150 - Issue P/O to ATG : PO 039046
sealant -Certificate of Conformity is required

FOLIO REV: _____ DWG REV: _____ 2-Deburr
ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water

FEB 14 2018 *mf*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X02.000	6061-T6 Bar .750 X 2.00	1.9800 ft (.11 ea)	90-Start up Operation	

FM137175 - 5041021

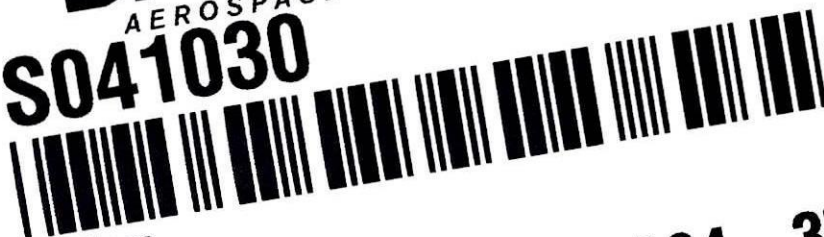
Part Specifications

Specifications could not be found.

Plex 1/17/18 11:36 AM Dart.lajeunesse.marie

42

DART
AEROSPACE
S041030



Bottom

PART NO:

Original Serial #: S041030

Revision:

Operation:

Change No:

RBE350A94-3700-C-05

Start up Operation

02/09/18
Job No: 170612

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



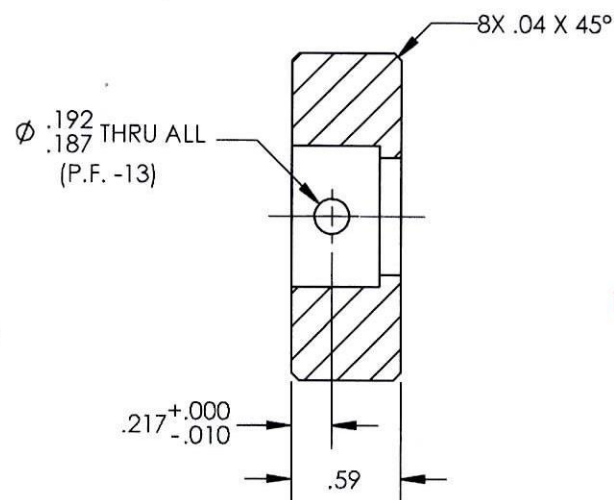
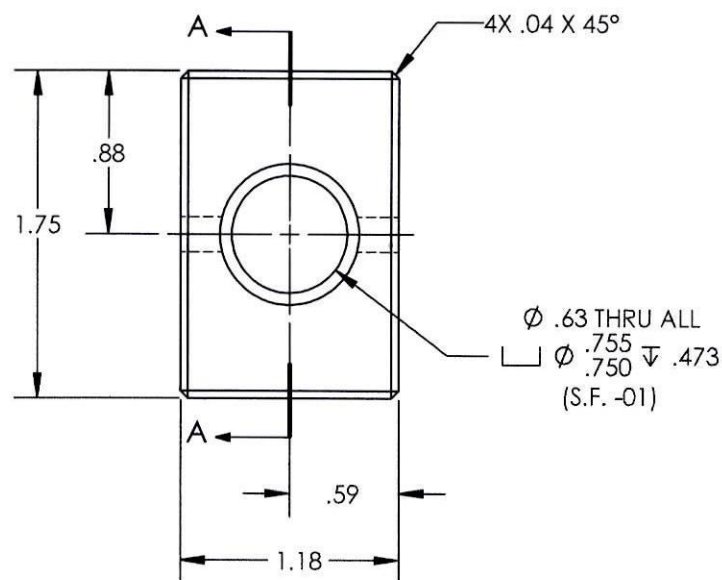
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-05 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187.	5/14/2015	RJC	JAG
6	16-0286	-05 CH'D DIM WAS Ø.625 THRU ALL $\square$ Ø.750 ∇ .473 S.F. -01 IS Ø.63 THRU ALL $\square$ Ø.755/.750 ∇ .473 (S.F. -01), WAS Ø.192/.187 THRU ALL IS Ø.192/.187 THRU ALL (P.F. -13), WAS .217 IS .217 +.000/-.010.	2/28/2017	RJC	SM



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170612 MJS
1801-19

⓪5
BOTTOM

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-05	REV 6
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH RED ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES Ø15 X 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 5 OF 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



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PURCHASE ORDER

PO039040

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	170612	RBE350A94-3700-C-05	As Per Dwg RBWSI-HT-12AS-1 Rev. E -Certificate of Conformity is required Bottom -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-05 Rev. 6 -Certificate of Conformity is required	Firmed	2/21/18	18 pcs	0 pcs	18 pcs	\$5.13/pcs	\$92.34
12	170629	RBE703A95-0508-00-1	Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C	Firmed	2/21/18	6 pcs	0 pcs	6 pcs	\$5.13/pcs	\$30.78
13	171659	T-8812187000	Drain Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg 8812187000 -Certificate of Conformity is required	Firmed	2/21/18	4 pcs	0 pcs	4 pcs	\$6.61/pcs	\$26.44

Grand Total: \$1,144.88

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

CL



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us		
10 ea	Part: RBWSI-HT-12AS-1 Top Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22551	Rev: E PO: PO039040	Line: 10
18 ea	Part: RBE350A94-3700-C-05 Bottom Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22552	Rev: 6 PO: PO039040	Line: 11
6 ea	Part: RBE703A95-0508-00-1 Quill Anodize per MIL-A-8625F, Type II, Class 2, Color, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22553	Rev: 5C PO: PO039040	Line: 12
4 ea	Part: T-8812187000 Drain Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22554	Rev: PO: PO039040	Line: 13
22 ea	Part: RBE350A94-3701-00 Main Rotor Rigging Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22549	Rev: 2A PO: PO039040	Line: 8
13 ea	Part: RBT18713-1 Body	Rev: 4	
Made in Canada.			

Made in Canada.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914652

Date: 22-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	Anodize per MIL-A-8625F, Type II, Class 2, red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 22550 PO: PO039040 Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.	